

5/15

DART AEROSPACE LTD	Work Order :	22587
Description: Aft Cap	Part Number:	D2646
Drawing: D2646 Rev. A	Qty:	40 39

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	HA	05.03.02	40
2	PURCHASING	Issue P/O: <u>2057679</u> Spin per Dwg D2646 Material release note required	U	05-03-02	40
3	QC	Inspect Level 6 Ensure material release note is attached	SB	05/04/29	40
4	METAL	Drill as per Dwg D2646 using DT 8026 Open holes to .19/64"	SB	05/05/02	39 (P10)
5	METAL	Deburr	SB	05/05/02	39
6		Acid etch and alodine as per QSI 005 4.1	ml	05 05 11	39
7	QC	Inspect Level 7	2	05 05 13	39
8	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	FF	05/05/12	
9	QC	Inspect Level 3	MM	05 05 12	
10	STORES	Pick: Qty <u>2</u> Part Number <u>ALS7-1032-130L or</u> <u>ALS7-1032-130 or</u> Description <u>Insert</u> Batch <u>M16197</u> <u>ALS4-1032-130</u>	FF	05/05/16	39
11	METAL	Install Inserts as per Dwg D2646	DT	05/05/16	39
12	QC	Inspect Level 7	2	05-05-16	39
13	STORES	Identify and Stock	MM	05 05 16	39
14 a	EXPEDITING	Close W/O <u>7.29</u> Cost / Part <u>2.77</u>	AP	05/05/17	39

Rev	Date	Change	Revised By	Approved
C	98.01.16	Changed Inspection Levels	BW	
D	99.01.04	Added Powder Coat	DM	
E	00.06.22	Removed P/O for powder coat	EC	

26	RG	Receive + Inspect for transit damage	CL	05/04/01	870
146	DL	Close w/o Inspect level 21	HA	05.05.24	39

RELEASED
JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/04/01	26	permanent change		05-04-25	N/A	W	 05-05-24

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/05/02	4	hole over tolerance	 05/05/02	Scrap	SB 05/05/02	 05-05-02	 05-05-02	 05-05-02

Part No: D2646 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 05/05/26

NOTE: Date & initial all entries

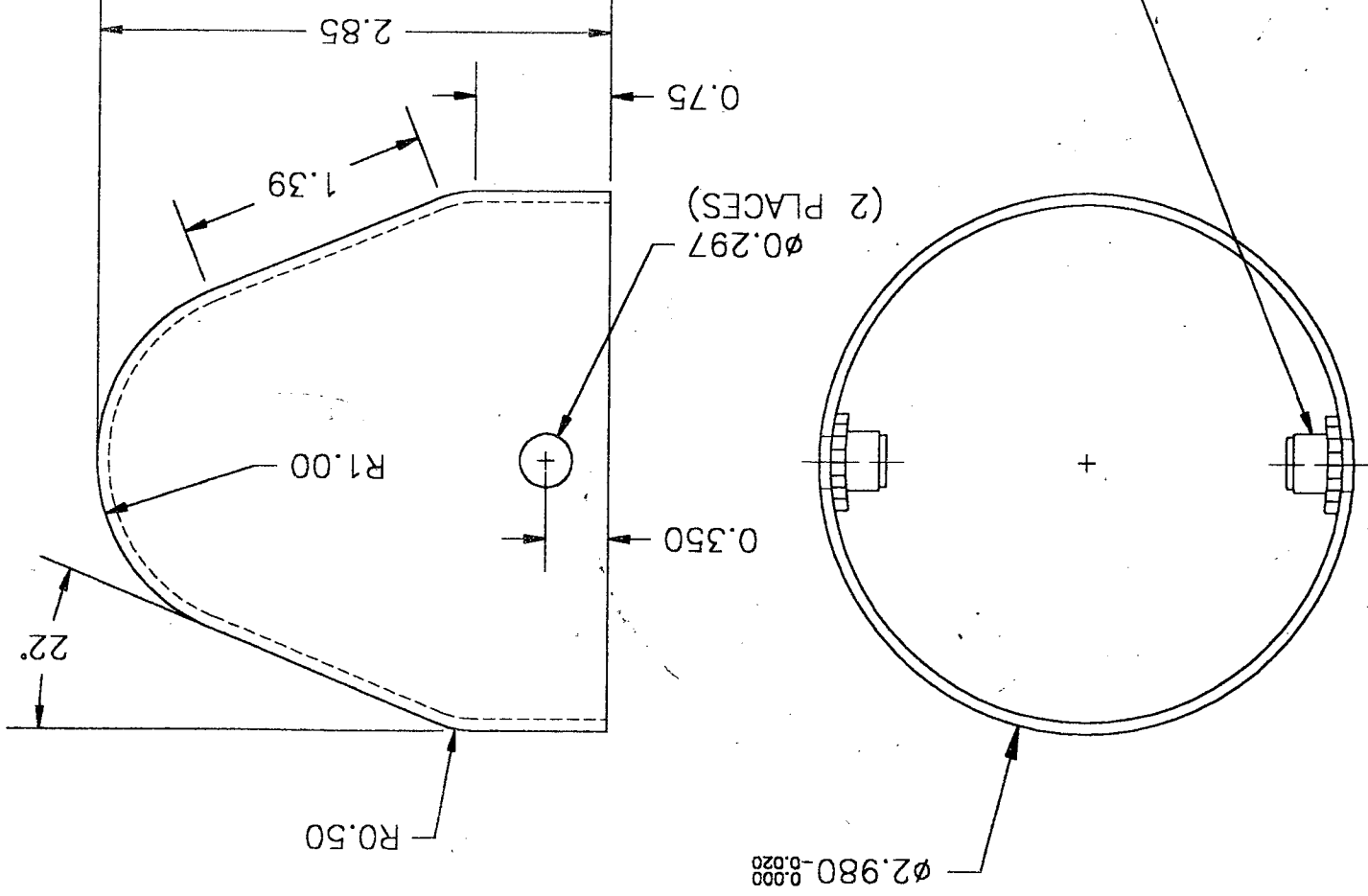
QA: N/C Closed: _____ Date: _____

DART



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2646	REV. A
DATE 97:03:25		TITLE CAP	SHEET 1 OF 1
		SCALE 1:1	

RELEASED
R 47/04/25 DS



MATERIAL: 1100-0 0.063 THICK (00-A-250/1)
FINISH: ACID ETCH, ALODINE PER DART QST 005 4.1
TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED

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FOR DOCUMENT
SHOOT NOTICE

WORK ORDER

NO. 22587

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

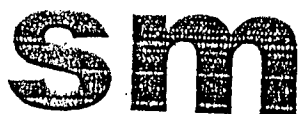
Mar 01, 2005
11:19 am

Work Order No : 0022587
Project Name : D2646
Project For : WK515
Work Order Type : Main
Main WO Number :
House Part Number : D2646
Description : Aft Cap
Manufactured : Yes
Amount Req'd : 40
Amount Done : 0
Start Date : 03-01-05
Est Finish Date : 03-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

INSPECTION REPORT

DATE: MAR 22 05

CUSTOMER: Dart

INVOICE #: 28717 SUPPLIER #: P62007679

DESCRIPTION OF INSPECTION: SPINNING PARTS

PART #	QTY.	MATERIAL	CHECK HOLES	DEBUR EDGES	INSP BY.
D2000-109	10	1100064	✓	✓	rlc
D2000-111	10	1100064	✓	✓	rlc
D26116 R.A.	40	1100064	✓	✓	rlc

NOTES OF INSPECTION:

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO

COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO

COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PO NO	C99792			MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO	050393-8			
ALLOY	1100	TEMPER	O	FORM	COIL	
GAUGE	.06300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 238066 COIL: B01 DROP: 440525

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
4405252	0.11	0.42	0.08	0.02	0.002	0.001	0.004	0.003	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JEFF FREEDY, LAB SUPERVISOR

Handwritten:
Henry C. S. 10/28
C/O
Sorel
LTS

